

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023979**Date Inspected:** 29-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

NDT

Outside Yard – OBG Trial Assembly

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted notification number 08981 and 08982.

Ultrasonic Testing (UT).

This QA inspector performed UT of approximately 10 % of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

SEG3007S-176, 178.

SEG3007R-150, 152.

SEG3013AA-110.

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This QA Inspector observed the following work in progress:

Outside Yard – OBG Trial Assembly

This QA Inspector observed ZPMC qualified welding personnel identified as 044772 perform welding by Shielded Metal Arc Welding (SMAW), on Side plate rib stiffener to Floor beam (FL3) weld at Panel Point 119 of OBG Segment 13AE. Weld joint is identified as SEG3007H-067. ZPMC Quality Control (QC) Inspector identified as Liu Hua Jie was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 043661 perform welding by Shielded Metal Arc Welding (SMAW), on Side plate rib stiffener to Floor beam (FL3) weld at Panel Point 119-1500 of OBG Segment 13AE. Weld joint is identified as SEG3007K-096. ZPMC Quality Control (QC) Inspector identified as Liu Hua Jie was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 068097 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam (FL3) rib stiffener to Floor beam (FL3) weld at Panel Point 120 of OBG Segment 13AE. Weld joint is identified as SEG3007B-169. ZPMC Quality Control (QC) Inspector identified as Liu Hua Jie was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066416 perform welding by Shielded Metal Arc Welding (SMAW), on K Plate rib stiffener to Floor beam weld on bike path side at Panel Point 120 of OBG Segment 13AE. Weld joint is identified as SEG3007C-307/308, 305/306. ZPMC Quality Control (QC) Inspector identified as Geng Wei was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066163 perform repair welding by Shielded Metal Arc Welding (SMAW), on Deck panel diaphragm to Floor beam diaphragm weld at Panel Point 119 of OBG Segment 13AE. Weld joint is identified as SEG3007J-011. ZPMC Quality Control (QC) Inspector identified as Geng Wei was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and Welding repair report B-WR20593.

This QA Inspector observed ZPMC qualified NDT personnel perform Magnetic Particle Testing on Deck panel diaphragm to Floor beam flange weld at Panel Point 119.65 of OBG Segment 13AE. Weld joint is identified as SEG3007D-220. See attached picture.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

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| Inspected By: | Upadhye, Anand | Quality Assurance Inspector |
| Reviewed By: | Clifford, William | QA Reviewer |
